

Ship March 7

Work Order ID 112827

February-10-14 7:38:07 AM

\*112827\*

Page 1

Item ID: D350-636-101

Revision ID:

Item Name: Toe Step

Start Date: 2/10/14 Start Qty: 12.00

Required Date: 2/28/14 Req'd Qty: 12.00

Reference:

D350-636-101  
B112827

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: ✓ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3487	Rev A

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-636-101 CHG001

MC5 14-02-14 (9)  
9 0 De  
14.02.10

110

0.00

\*110\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg \*\*\* D3487-1\*\*\*

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

9 0 De  
14.02.10



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Page 2

**DAS  
30  
9-89**

9 0 ~~Ac~~  
14-02-10

9 0 \_\_\_\_\_  
mm.l  
14/02/10

9 \_\_\_\_\_ 14/10/20

**Work Order ID 112827**

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**\*112827\***

Page 3

Item ID: D350-636-101

Accept

**\*N19000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Toe Step

Start Date: 2/10/14

Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 2/28/14

Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

DAS  
27  
3-89

9

**\*160\***

QC

Memo

0.00

Quality Control

18-2-11

170

Chemical Conversion Coat per QSI005 4.1

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

9

MG 142-12

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*180\***

Powdercoat

Memo

0.00

Powder Coating

9

H-2-12

DAS 34 9-89

START TIME:

1:50

OVEN TEMPERATURE:

320

FINISH TIME:

2:20

# Work Order ID 112827

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**\*112827\***

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Item ID: D350-636-101      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Toe Step  
 Start Date: 2/10/14      Start Qty: 12.00      **\*12\***      Cust Item ID:  
 Required Date: 2/28/14      Req'd Qty: 12.00      **\*12\***      Customer:  
 Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>1128</u> 102  Memo	0.00  0.00				9x	4	14102/13	
200 <b>*200*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				9			
210 <b>*210*</b> Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D350-636-101 Location: <u>120</u> PPP Rev: _____	0.00  0.00				9	14-2-24		

DAS  
6  
9-89



**Work Order ID 112827**

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Item ID: D350-636-101

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Toe Step

Stop **\*NS2\***

Start Date: 2/10/14 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 2/28/14 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

QC21- Final Inspection - Work Order Release

0.00

**\*230\***

QC

Memo

0.00

Quality Control

MLJ 14-02-28

14-02-27





# Picklist Print

February-10-14 7:38:07 AM

Page 1

Work Order ID: 112827

Parent Item: D350-636-101

Start Date: 2/10/14

Required Date: 2/28/14

Parent Item Name: Toe Step

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-03-03 JLM  
house DD verf:JLM

IPP Rev:B 11.03.15 now made in

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100 6061-T6 .100 Sheet		Purchased	No			110	sf	13.0000	0.7942	11			

*De 14-02-10*

Location

Loc Qty

Loc Code

MAT021

13

124193

13

124193

→ (11)

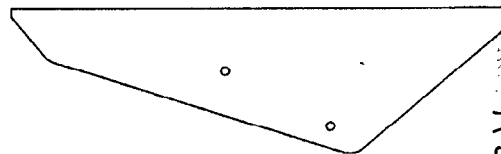
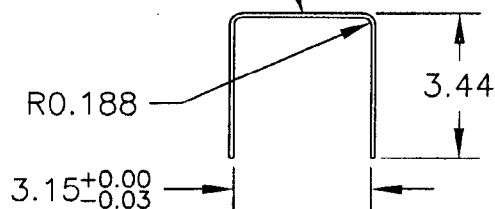
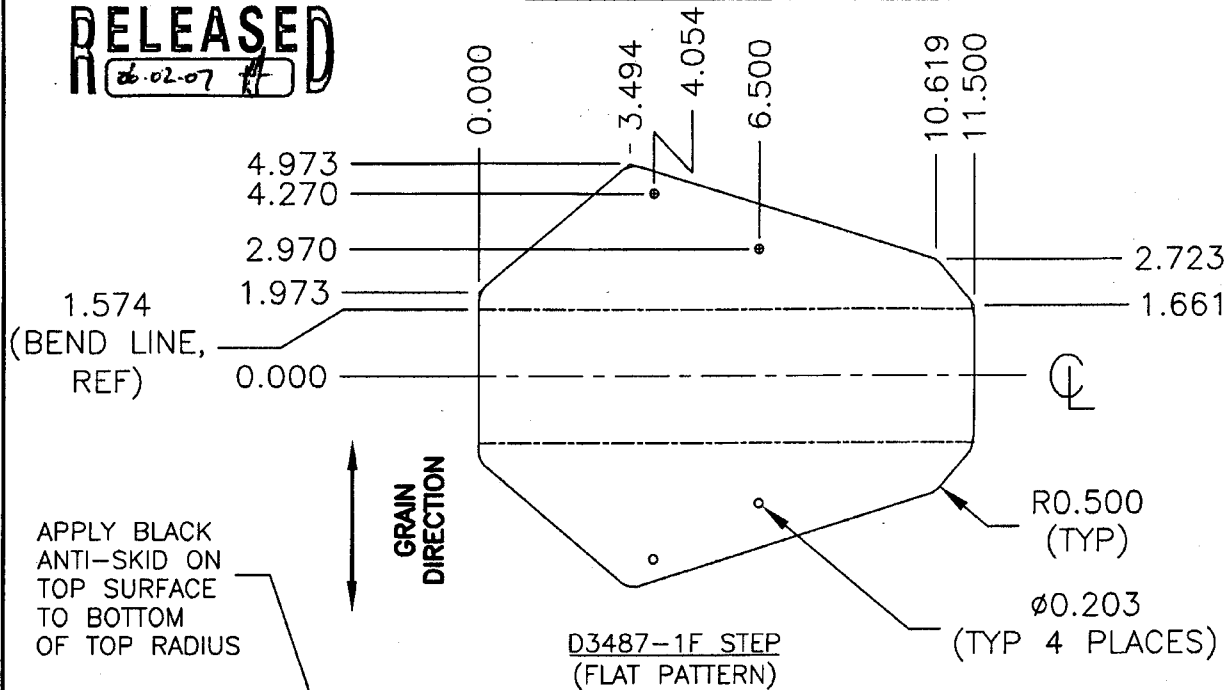






DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED AL	APPROVED AL	DRAWING NO. D3487	REV. A SHEET 1 OF 1
DATE 06.01.16		TITLE STEP	SCALE 1:4
A	06.01.16	NEW ISSUE	

RELEASED  
2-02-07



#### D3487-1 STEP

- 1) MATERIAL: ALUMINUM 6061-T6/T651 ALUMINUM (QQ-A-250/11) 0.100 THICK (REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO TOP SURFACE PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE
- 6) BREAK UNMARKED EDGES 0.005 TO 0.010 MAX

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